

Work Order ID 163433

Tuesday, June 27, 2017 12:10:31 PM

163433

Page 1

Item ID: D4866-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206L AFT Leg Assembly, RH
Start Date: 7/5/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/21/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: **JUL 03 2017** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4866	C ✓								

110

0.00

110

Small Fab

Small Fab

Memo

2.23

ALIGN PILOT HOLES IN D4866-2 WITH PILOT HOLES IN D4870-1 AND
D4870-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
DWG.
REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
DT9963 AS PER DWG.

4 _____ MLC
17-8-10

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.08

4 _____ QB
17-08-11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
☐ OTHER : _____						

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

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163433

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

4

4

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

160

Receive & Inspect for Damage & Mat'l Certs

0.00

160

Packaging

Memo

0.08

Packaging

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.08

Quality Control

Identify as per dwg & Stock Location: ST 45 0.00

180

180

Packaging

Memo

0.04

Packaging

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 163433

Tuesday, June 27, 2017 12:10:31 PM

163433

Page 4

Item ID: D4866-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206L AFT Leg Assembly, RH

Start Date: 7/5/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.40

Quality Control

Um 17/8/22

DAS
21
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Tuesday, June 27, 2017 12:10:29 PM

Page 1

Work Order ID: 163433

163433

Parent Item: D4866-042

D4866-042

Parent Item Name: 206L AFT Leg Assembly, RH

Start Date: 7/5/2017

Required Date: 7/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL32PB5-12 *HI 32PR5-12* Hi-Lok Pin		Purchased	No			110	Each	67.0000	4	16			
									**				MLL 17-8-10
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST562				67					
				m137222				17					
				<u>m137687</u>				50		16			
D4866-2 *D4866-2* Strut		Manufactured	No			110	Each	7.0000	1	4			
									**				MLL 17-8-10
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST130				7					
				121501				7		4			
D4870-1 *D4870-1* End Fitting, Small		Manufactured	No			110	Each	17.0000	1	4			
									**				MLL 17-8-10
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST131				17					
				121621				17		4			
D4870-3 *D4870-3* End Fitting, Large		Manufactured	No			110	Each	16.0000	1	4			
									**				MLL 17-8-10
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST131				16					
				121535				16		4			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Picklist Print

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Page 2

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Parent Item: D4866-042

D4866-042

Parent Item Name: 206L AFT Leg Assembly, RH

Start Date: 7/5/2017

Required Date: 7/21/2017

Start Qty: 4.00

Required Qty: 4.00

HL86-5

Purchased

No

110

Each

212.0000

4

16

HI 86-5

Hi-Lok Collar

MLL

17-8-10

Location

Loc Qty

Loc Code

ST562

212

M129022

200

~~M129864~~

12

16

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

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OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37424**

Purchase Order Date 8/15/2017

PO Print Date 8/15/2017

Page Number 1 of 3

Order From :
P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

VC-PL001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

2017/08/15

Contact Name
Vendor Phone 613-931-1241

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	163433	D4866-042 206L AFT Leg Assembly, RH	8/22/2017	No	4.00	\$4.00	\$16.00
	Engrave P# as per Dwg D4866 Rev.C		8/22/2017				
Line Total:							\$16.00
2	163376	D4868-041 206L Leg Assembly	8/22/2017	No	4.00	\$4.00	\$16.00
	Engrave P# as per Dwg D4868 Rev. C		8/22/2017				
Line Total:							\$16.00
3	160683	D4834-041 206L MID Leg Assembly, LH	8/22/2017	No	2.00	\$4.00	\$8.00
	Engrave P# as per Dwg D4834 Rev. C		8/22/2017				

Note:

8/15/2017



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE August 18, 2017

P.O NUMBER PO37424

ITEM DESCRIPTION**QUANTITY****COMMENTS**

D4866-042 LEG ASSEMBLY

4

ALL ITEMS HAVE BEEN LASER MARKED

D4868-041 LEG ASSEMBLY

4

D4834-041 LEG ASSEMBLY

2

D4882-042 LEG ASSEMBLY

2

D4882-041 LEG ASSEMBLY

2

SP17-8-21



19226 Airport Road
Summerstown, ON
K0C 2E0

plprinting@bellnet.ca

Tel.: 613 931-1241
Fax: 613 931-2560

www.plprinting.ca

Invoice

Number: 9315

Date: August 18, 2017

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
37424		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4866-041	4.00	4.00	✓	16.00
Laser Metal Marking, D4868-041	4.00	4.00	✓	16.00
Laser Metal Marking, D4834-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4882-042	2.00	4.00	✓	8.00
Laser Metal Marking, D4882-041	2.00	4.00	✓	8.00
Sub-Total				\$56.00
13.00% on 56.00				7.28
Total				\$63.28

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*Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.*

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You